

Work Order ID 64015

November 23, 2010 7:29:53 AM

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Item ID: D2534

Accept

Revision ID:

Item Name: Lock Plate

Setup Start

Stop

Start Date: 11/24/10 Start Qty: 20.00

Required Date: 11/25/10 Req'd Qty: 20.00

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2534

Rev D

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D2734 Dwg Rev: D IProg Rev: D 12-
Debur if necessary

110-11-23

(22)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

110-11-23

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

8.00/173

count
(+22)

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Item ID: D2534

Accept



Setup Start



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Stop



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Start Date: 11/24/10 Start Qty: 20.00



Cust Item ID:

Required Date: 11/25/10 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Identify as per dwg & Stock Location: WA21

0.00



Packaging

Memo

0.00

Packaging

*****STOCK IN LARGE FAB*****

QC 10-11-24

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/25 JH

MF 10-11-24

Picklist Print

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Work Order ID: 64015

Parent Item: D2534

Parent Item Name: Lock Plate



Start Date: 11/24/10

Required Date: 11/25/10

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP Rev:A New Issue 05-11-07 JLM
IPP Rev:B Now on Waterjet 06-06-20 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased	No			110	sf	36.2523	0.0427	0.898947			



304/316 0.125 Sheet



11/24/10

Location

Loc Qty

Loc Code

MAT

36.2523

114799

36.2523

114799

02

DART AEROSPACE LTD		Work Order: <i>6405</i>
Description: Lock Plate		Part Number: D2534
Inspection Dwg: D2534	Rev: D	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article
 ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.447	+0.006/-0.001	.452	<i>x</i>		V HB02	
R0.500	+/-0.010	.500	<i>x</i>		R.G.	
R0.173	+/-0.010	.173	<i>x</i>		R.G.	
R0.096	+/-0.010	.096	<i>x</i>		R.G.	
R0.125	+/-0.010	.125	<i>x</i>		R.G.	
R0.120	+/-0.010	.120	<i>x</i>		R.G.	
R0.200	+/-0.010	.200	<i>x</i>		R.G.	
0.125	+/-0.010	.117	<i>x</i>		V	

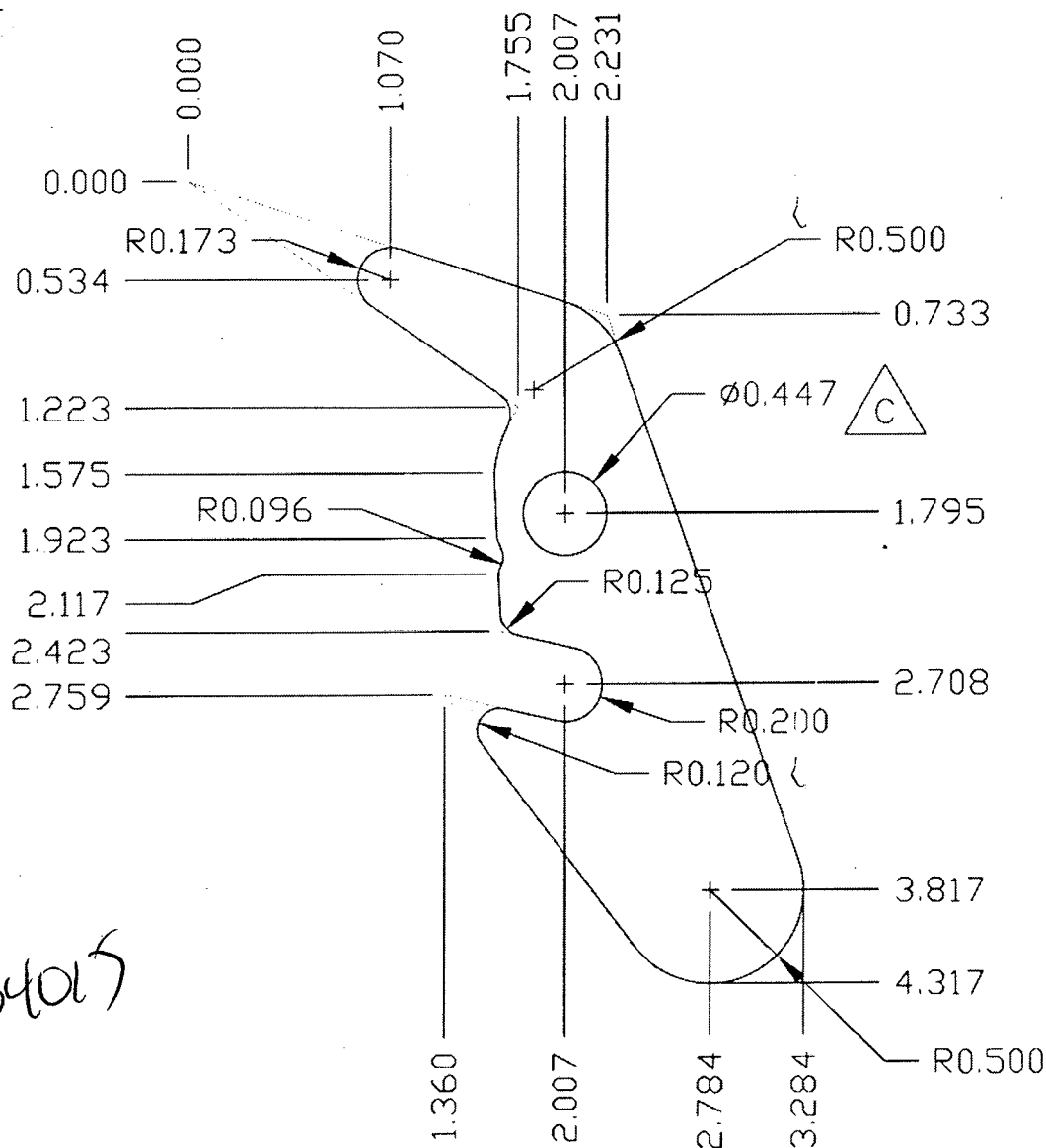
Measured by: <i>18</i>	Audited by: <i>S</i>	Prototype Approval:	N/A
Date: <i>10-11-20</i>	Date: <i>10/6/23</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.14	New Issue	KJ/J'-M <i>JA</i>	<i>JA</i>



DESIGN	DRAWN BY	DART AEROSPACE LTD	
B WILLIAMS	PH	VICTORIA INTERNATIONAL AIRPORT, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. D
<i>[Signature]</i>	<i>[Signature]</i>	D2534	SHEET 1 OF 1
DATE	TITLE		SCALE
04.12.14	LOCK PLATE		1:1
C	96.07.26	HOLE WAS 0.328	
D	04.12.14	UPDATE NOTES	

RELEASED
04.12.16 *[Signature]*



D2534 LOCK PLATE

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET 11 GAUGE (0.125 THICK)
(REF. DART SPEC. M304S11GA)
- 2) FINISH: NONE
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.015
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED